

Work Order ID 73110

Thursday, August 25, 2011 4:09:55 PM



Page 1

Item ID: D2672

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 13" X 24", 206

Start Date: 8/26/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: C2

Date: 11/08/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2672

Rev B1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D2672_BLANK

B11-9-30

4

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672
3-Deburr

F.K. - 11/10/29

5

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

F.K. - 11/10/29

5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73110

Thursday, August 25, 2011 4:09:55 PM



Page 2

Item ID: D2672

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 13" X 24", 206

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

out 11/10/30

5 2

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

PAP75321

0.00

Packaging

11/11/01 (5)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/01

ME 11-11-01

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 4:09:46 PM

Page 1

Work Order ID: 73110

Parent Item: D2672

Parent Item Name: Bearpaw 13" X 24", 206




Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10  UHMW 1" Black | | Purchased | No | | | 120 | sf | 414.2200 | 3.6 | 14.4 | | | |



18119-30

Location

Loc Qty

Loc Code

MAT018

414.22

117321

76.6

117738

124.3

117819

129.9

118257

83.42

118257

④

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|-------------------------------|--|--------------|-------|
| DART AEROSPACE LTD | | Work Order: | 73110 |
| Description: Bearpaw | | Part Number: | D2672 |
| Inspection Dwg: D2672 Rev: B1 | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|-------------------------|--------------|
| A | 23.750 | +/-0.030 | 23.750 | ✓ | | FK-05 | Tape. |
| B | 12.750 | +/-0.030 | 12.750 | ✓ | | " | " |
| C | 4.250 | +/-0.010 | 4.254 | ✓ | | FK-04 | Vern. |
| D | 2.000 | +/-0.030 | 2.010 | ✓ | | " | " |
| E | 9.000 | +/-0.010 | 9.000 | ✓ | | CNC-02 | " |
| F | 0.375 | +/-0.030 | 0.380 | ✓ | | FK-04 | " |
| G | 9.000 | +/-0.010 | 9.000 | ✓ | | FK-04 CNC-02 | Vern. |
| H | Ø0.260 | +0.005/-0.000 | 0.260 | ✓ | | FK-04 | Vern. |
| I | Ø0.93 | +/-0.030 | 0.930 | ✓ | | " | " |
| J | 0.300 | +0.030/-0.000 | 0.310 | ✓ | | FK-06 | Depth gauge |
| K | 0.625 | +/-0.030 | 0.627 | ✓ | | FK-04 | Vern. |
| L | 0.063 x 45° | +0.030/-0.010 | 0.063 x 45° | ✓ | | " | " |
| M | 0.250 | +/-0.010 | 0.253 | ✓ | | | Height gauge |
| N | 5.500 | +/-0.030 | 5.500 | ✓ | | FK-04 | Vern. |
| O | R0.250 | +/-0.030 | 0.250 | ✓ | | rad gauge | |
| P | 0.200 | +/-0.030 | 0.190 | ✓ | | FK-06 | depth gauge |
| Q | 0.25 x 45° | +/-0.030 | 0.25 x 45° | ✓ | | FK-04 | Vern. |
| R | 0.950 | +0.030/-0.010 | 0.954 | ✓ | | " | " |
| S | 0.375 | +/-0.010 | 0.377 | ✓ | | " | " |
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|------------------------|-----------------------|---------------------|-----|
| Measured by: <u>FK</u> | Audited by: <u>am</u> | Prototype Approval: | N/A |
| Date: <u>11/10/29</u> | Date: <u>11/10/30</u> | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------|-----------|
| A | 03.09.22 | New Issue | KJ/RF <u>af</u> | <u>af</u> |

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NOTE: Date & initial all entries

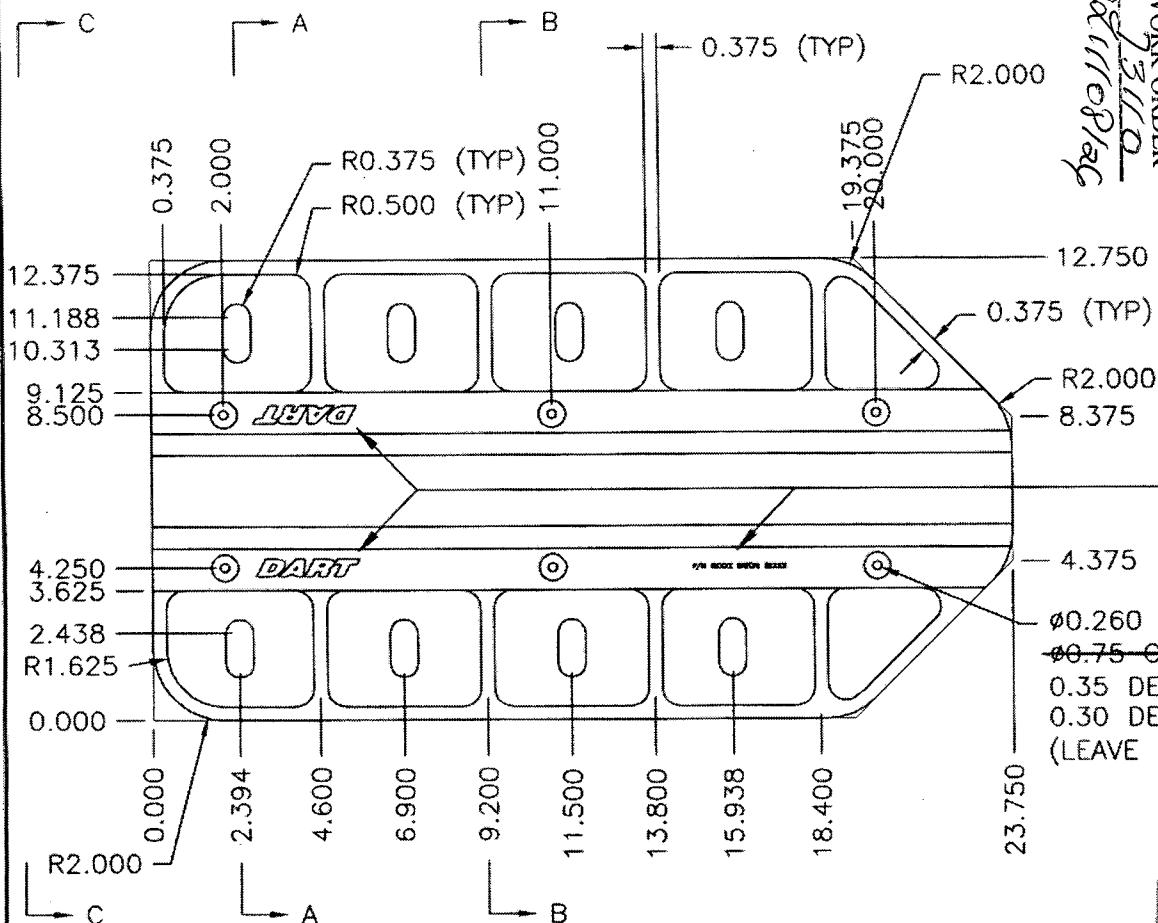




| | | | | | |
|----------|----------|-------------|--------------------------------|--------------|--|
| DESIGN | | DRAWN BY | | REV. B | |
| KE | | KE | | | |
| CHECKED | APPROVED | DRAWING NO. | | SHEET 1 OF 2 | |
| MB | AS | D2672 | | | |
| DATE | | TITLE | | SCALE | |
| 98.05.19 | | BEARPAW | | 1:5 | |
| A | | 97.04.08 | NEW ISSUE | | |
| B | | 98.05.19 | CHANGE C'BORE, R1.58 WAS R1.50 | | |
| B1 | | 22.10.22 | Φ0.93 WAS Φ0.75 | | |

ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)

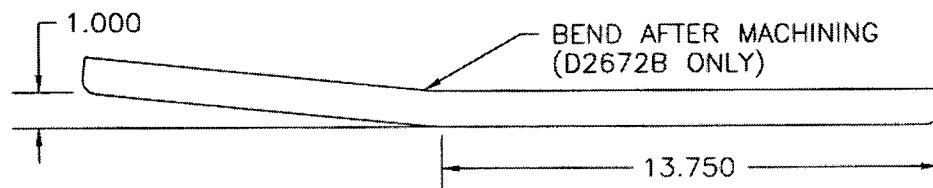
WITHOUT NOTICE
WORK ORDER
7266

02/21/2024



00.260 (TYP) 
~~00.75 C'BORE~~ ϕ 0.43 C'BORE
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.) 

FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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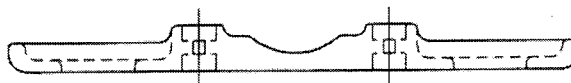
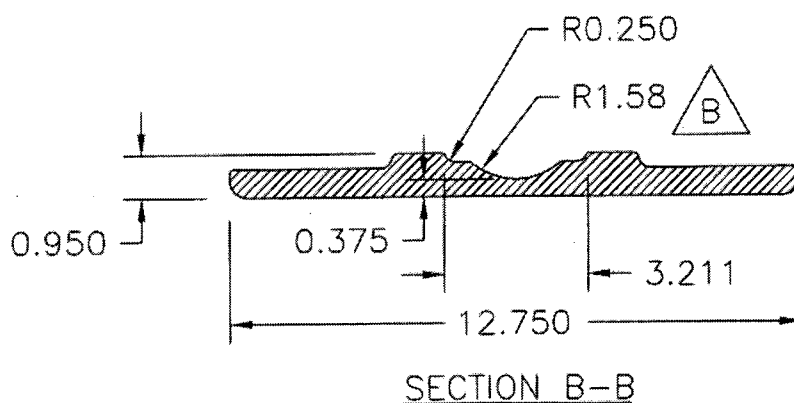
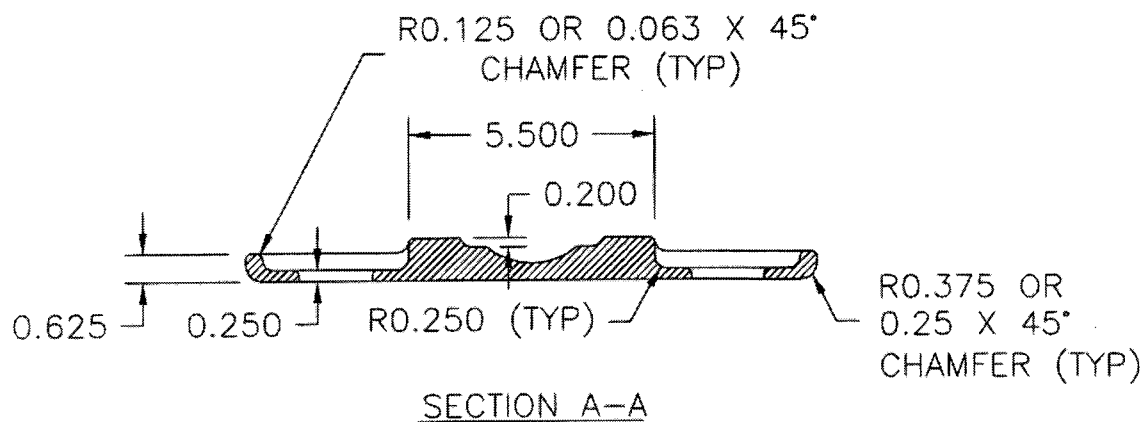
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2672 | REV. B SHEET 2 OF 2 |
| DATE 98.05.19 | | TITLE BEARPAW | SCALE 1:4 |

RELEASED
99.06.17 KE



SECTION C-C

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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